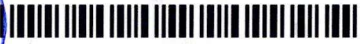


	Dart Aerospace Ltd. 1270 Aberdeen St Hawkesbury, ON K6A 1K7 Canada	20NR-64 Job Sheet 192898
	Tel (613) 632-5200 Fax 613 632-5246	
Part No: 20NR-64 Part Name: Flat Bumper 	Job Qty: 27 pcs (circled 17) Status: New Job Tracking No: Created By: Jennifer Renwick Description: Note: 20NR-64 REV.A IPP REV:A 17.11.15 NEW ISSUE DD VERF:JFS Ship Via:	Priority: Medium DA6 21 9-88
Bill of Materials		


Container No: S183003

Part: 20NR-64
Job No: 192898
Serial No/Batch: S183003
Revision: A
Inspector:
Exp Date:
Instructions:

1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 05/22/19

Job Routing							
Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs Run Hrs	Workcenter/Supplier	
						Workcenter / Supplier Lead Time Sign-off	
100	External Load - 1	27 pcs		5/10/19	0.00 3.00	External Load - 1 - B4B External Load - 2 - B4B External Load - 3 - B4B	AP 2019/05/22
110	QC 5	27 pcs		5/10/19	0.00 0.00	QC 5 - 10 QC 5 - 12 QC 5 - 17 QC 5 - 18 QC 5 - 19 QC 5 - 22 QC 5 - 24 QC 5 - 3 QC 5 - 43 QC 5 - 49 QC 5 - 51 QC 5 - 58 QC 5 - 68 QC 5 - 9 QC 5 - 50 QC 5 - 30 QC 5 - 40	DAS MAY 22 2019 40 9-89
130	Packaging 3-1 - Stock - B4B	27 pcs		5/10/19	0.00 0.00	Packaging 3 - 1 - B4B Packaging 3 - 2 - B4B Packaging 3 - 3 - B4B Packaging 3 - 4 - B4B Packaging 3 - 5 - B4B Packaging 3 - 6 - B4B Packaging 3 - 7 - B4B Packaging 3 - 8 - B4B Packaging 3 - 9 - B4B Packaging 3 - 10 - B4B Packaging 3 - 11 - B4B Packaging 3 - 12 - B4B Packaging 3 - 13 - B4B Packaging 3 - 14 - B4B Packaging 3 - 15 - B4B Packaging 3 - 16 - B4B Packaging 3 - 17 - B4B Packaging 3 - 18 - B4B Packaging 3 - 19 - B4B Packaging 3 - 20 - B4B Packaging 3 - 21 - B4B Packaging 3 - 22 - B4B Packaging 3 - 23 - B4B Packaging 3 - 24 - B4B Packaging 3 - 25 - B4B Packaging 3 - 26 - B4B Packaging 3 - 27 - B4B Packaging 3 - 28 - B4B Packaging 3 - 29 - B4B Packaging 3 - 30 - B4B Packaging 3 - 31 - B4B Packaging 3 - 32 - B4B Packaging 3 - 33 - B4B Packaging 3 - 34 - B4B Packaging 3 - 35 - B4B Packaging 3 - 36 - B4B	
140	QC 21 - SA	27 pcs		5/10/19	0.00 0.00	QC 21 - SA - 21 QC 21 - SA - 70 QC 21 - SA - 53	DAS 21 MAY 23 2019 9-89

Part Op 100 - Small Fab - 1-Mix 80A liquid urethane using base and activator as per manufacturer instructions. A/R;
 Descriptions: M _____ EXP. _____ 2-Pour into DT10517 Mold. 3-Let cure as per manufacturer instructions. Time;
 _____ Date; _____ 4-Remove from mold. 5-Cut to length as per drawing. 6-Debur if required.
 130 - Identify as per dwg & Stock Location: _____
 140 - QC21- Final Inspection - Work Order Release

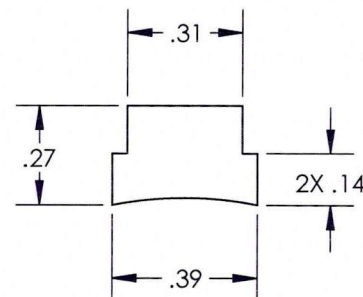
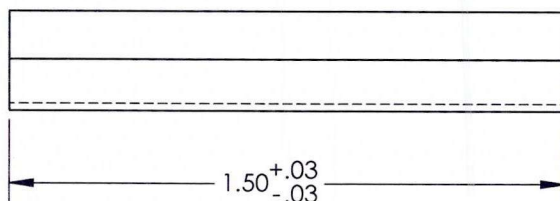
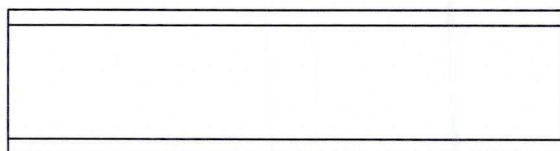
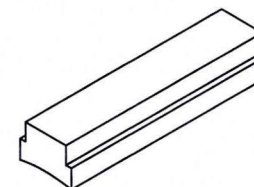
Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
8644K12	80A Liquid Urethane	.0270 pcs (.001 ea)	100-External Load - 1	5170551
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-External Load - 1	8644K12	0	1	0
Part Specifications				
Specifications could not be found.				

Plex 4/3/19 1:18 PM Dart.Renwick.Jennifer

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
A	14-0102	CH'D TITLE BLOCK WAS RED BARN IS DART. ADDED BAG & LABEL NOTE.	7/30/2014	DJN	RW

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 192898



NOTES:

1. USE FIXTURE 20NR-64-F AS CASTING MOLD.
2. RADIUS IS FOR SHRINKAGE NOT CRITICAL.
3. BAG & LABEL WITH BATCH NUMBER.

USED ON
20NR
8NR

DART AEROSPACE	
TITLE FLAT BUMPER	
DWG NO. 20NR-64	REV A
MAT'L POLYURETHANE	DRAWN BY: SMITH
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .005 .XX ± .01 .X ± .1	HEAT TREAT FINISH
FRACTIONS ± 1/32 ANGLES ± 5°	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 2:1	DATE 8/13/2013 SHEET 1 OF 1

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS
			20NR-64	1	FLAT BUMPER	POLYURETHANE	3/8 X 3/8 X 1-1/2

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details: _____					